

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024763**Date Inspected:** 27-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As listed below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 9E PP76 E4 Lifting Lug Hole #2
2. 9W PP79 W4 Lifting Lug Hole #3
3. 10W PP92 W3 Lifting Lug Hole #1
4. 9W PP79 W4 Lifting Lug Hole #1
5. Lifting Lug Ultrasonic Testing

1. 9E PP76 E4 Lifting Lug Hole #2

The QA Inspector periodically observed ABF welding operator Jorge Lopez ID# 6149 perform SMAW in the 1G flat position on Lifting Lug Hole (LLH) #2 at 9E PP76 E4 outside of the OBG. The QA Inspector observed the QC Inspector Fred Von Hoff as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

2. 9W PP79 W4 Lifting Lug Hole #3

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

The QA Inspector made periodic observations of ABF welder Fred Kaddu ID# 2188 performing SMAW in the 1G flat position on LLH #3 located at 9W PP79 W4. The QA Inspector observed the QC Inspector Pat Swain as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work was completed on this date and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

3. 10W PP92 W3 Lifting Lug Hole #1

The QA Inspector randomly observed ABF welder Darcel Jackson ID# 9967 performing SMAW in the 4G overhead position on LLH #1 at 10W PP92 W3. The QA Inspector observed the QC Inspector Pat Swain as being present in order to monitor the progress and ensure the welding parameters were in compliance with ABF-WPS-D15-1110A Rev. 1. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 9W PP79 W4 Lifting Lug Hole #1

The QA Inspector periodically observed ABF welding operator Fred Kaddu ID# 2188 perform SMAW in the 1G flat position on LLH #1 at 9W PP79 W4 outside of the OBG. The QA Inspector observed the QC Inspector Pat Swain as being present in order to monitor the progress and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1050A-CU. The work progressed throughout the QA Inspector's shift. The QA Inspector noted that the work was in progress and appeared to be in general conformance with the contract documents.

5. Lifting Lug Ultrasonic Testing

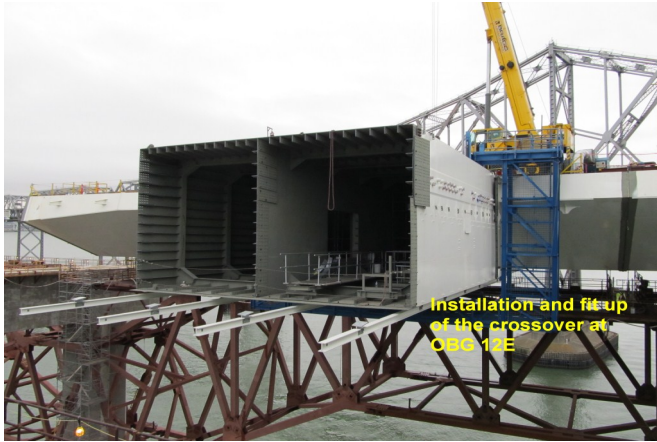
The QA Inspector performed straight beam UT on random areas adjacent to the Lifting Lugs which are attached to the OBG Floor Beams in each segment. The following locations were tested; #2 & 4 at 6W PP44 W4, #2 & 4 at 7W PP56 W3, #1 & 3 at 8W PP68 W4, #1 & 3 at 9W PP76 W3, #2 & 4 at 10W PP89 W4, and #2 & 4 11W PP100 W3. The areas were found to be free of indications and acceptable. The scan was performed in the defined UT area on drawings ZPM-04-01-001216 to ZPM-04-01-001219 where accessible. The work is in progress and appeared to be in general conformance with submittal 1635 Rev.00.

Summary of Conversations:

At the beginning the shift the QA Inspector met with QC Inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer